

Work Order ID 78663

78663

Page 1

January-12-12 10:13:49 AM

Item ID: D3065-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 12/01/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 19/01/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3065 Dwg Rev: B Prog Rev: B 2-
 Deburr as required

B12-1-13

(57)

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

B12-1-13

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

8/2/12/15

count
 (57)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

51 X 0 M / 12/04/19

51 R 10-1-19

12/01/20 (51)

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/1/23
(51)

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Picklist Print

January-12-12 10:13:54 AM

Page 1

Work Order ID: 78663

78663

Parent Item: D3065-1

D3065-1

Parent Item Name: Step Spacer

Start Date: 12/01/2012

Required Date: 19/01/2012

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF
IPP: D06.04.25 Water jet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

170.3184

0.1238

6.515789

M2024T3S 040

2024-T3 .040 sheet

**

B12-1-13

Location

Loc Qty

Loc Code

MAT022

170.318421

117684

26.318421

120196

144

120196

(52)

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DART AEROSPACE LTD		Work Order: 78663
Description: Step Spacer		Part Number: D3065-1
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.252	✓		V BOZ	
2.093	+/-0.010	2.091	✓		V	
3.936	+/-0.010	3.935	✓		V	
4.186	+/-0.010	4.192	✓		V	
0.587	+/-0.010	.589	✓		V	
Ø0.128	+0.005/-0.001	.130	✓		V	
R0.125	+/-0.010	.125	✓		R.G.	
3.465	+/-0.010	3.463	✓		V	
Ø1.250	+0.012/-0.001	1.253	✓		V	
0.368	+/-0.010	.367	✓		V	
0.871 (Pitch)	+/-0.005	.872	✓		V	
0.040	+/-0.010	.042	✓		V	

Measured by: IB
Date: 12-1-13

Audited by: S
Date: 12/1/15

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

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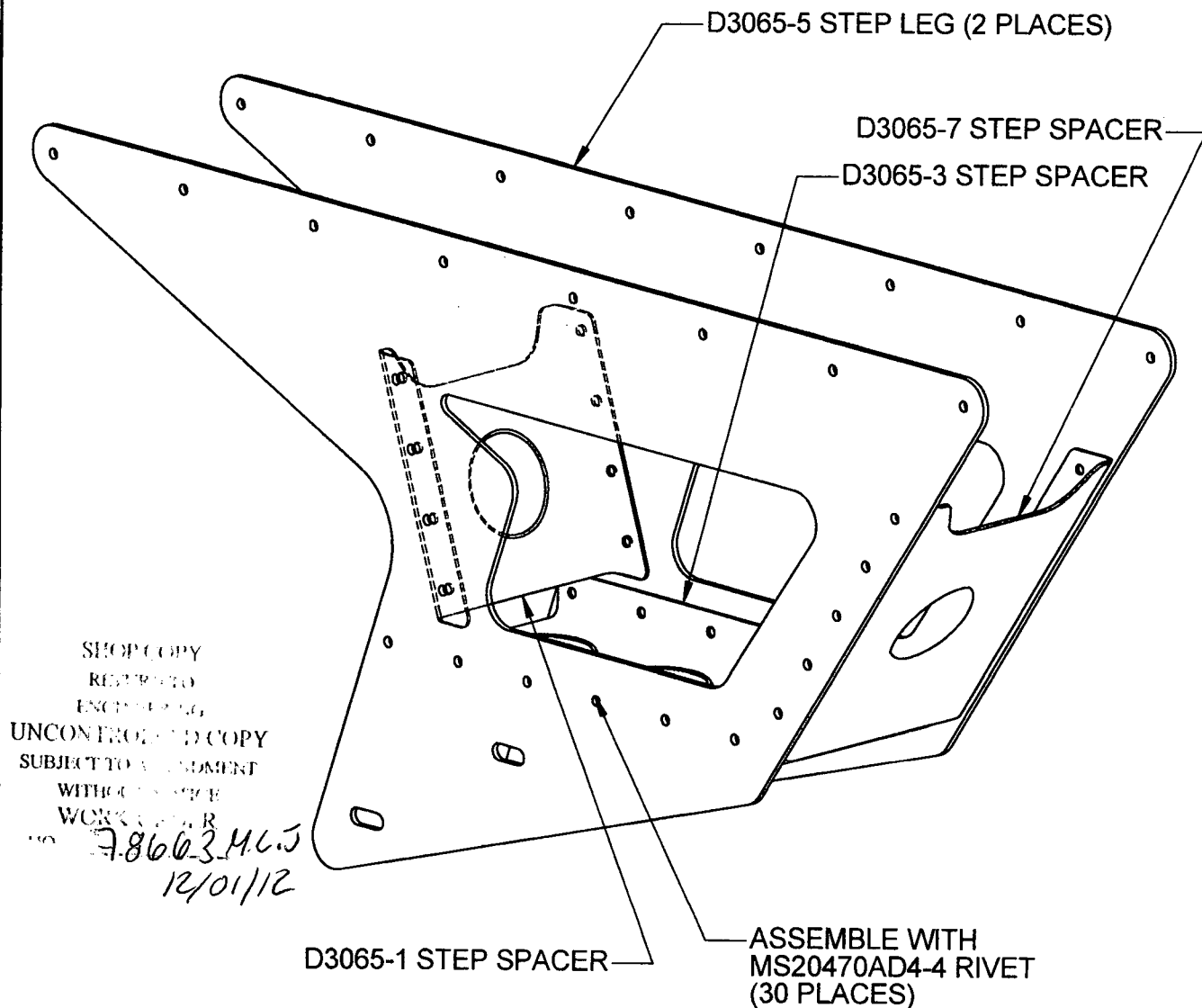
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



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WORK CENTER

7.8663-46.5
12/01/12

D3065-041 STEP LEG ASSEMBLY

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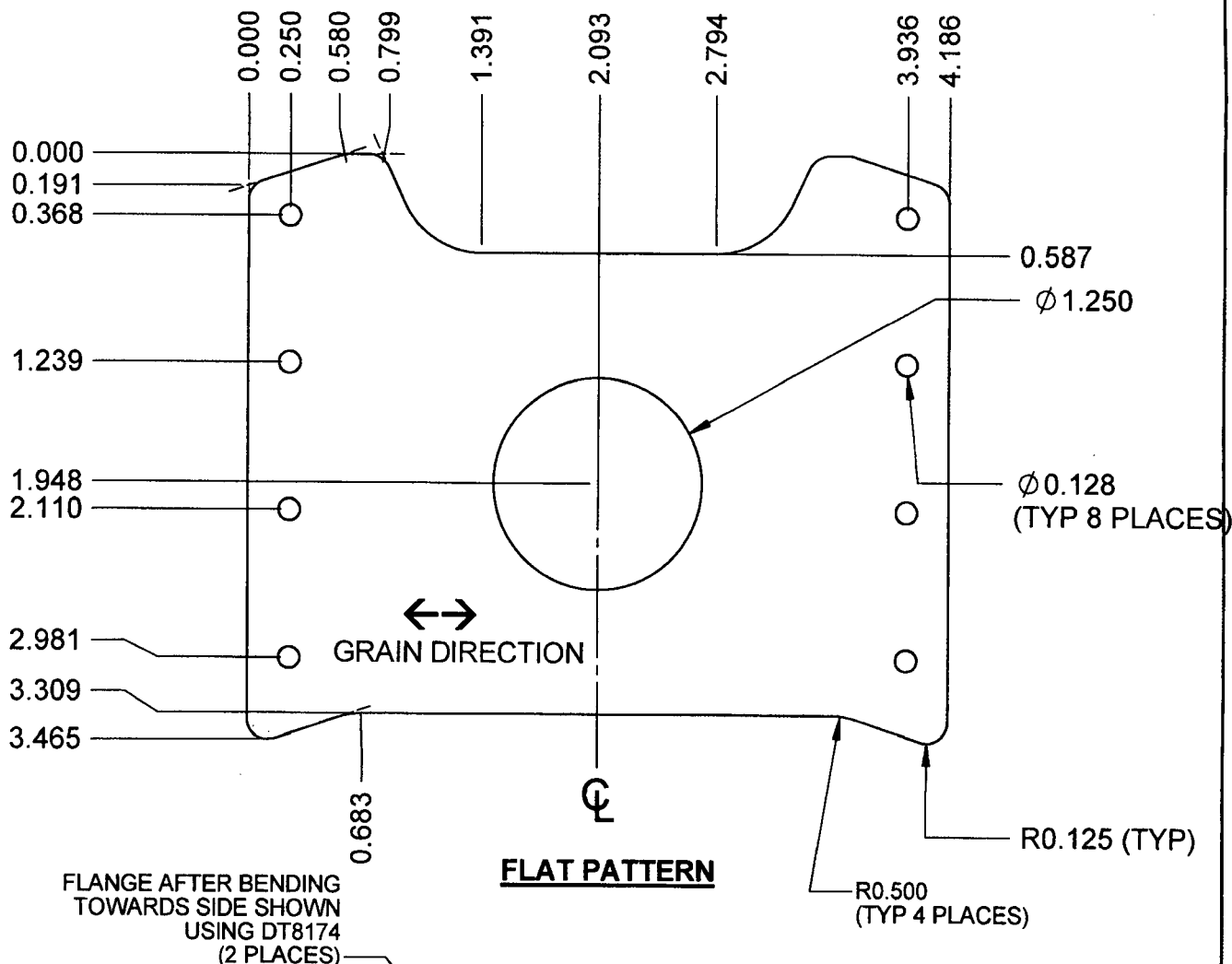
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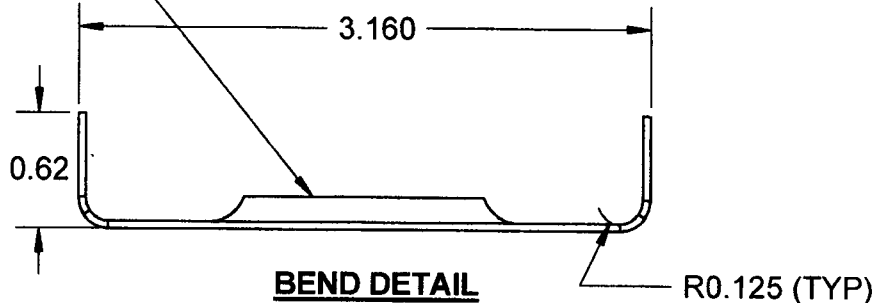
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DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



RELEASED
cl de re



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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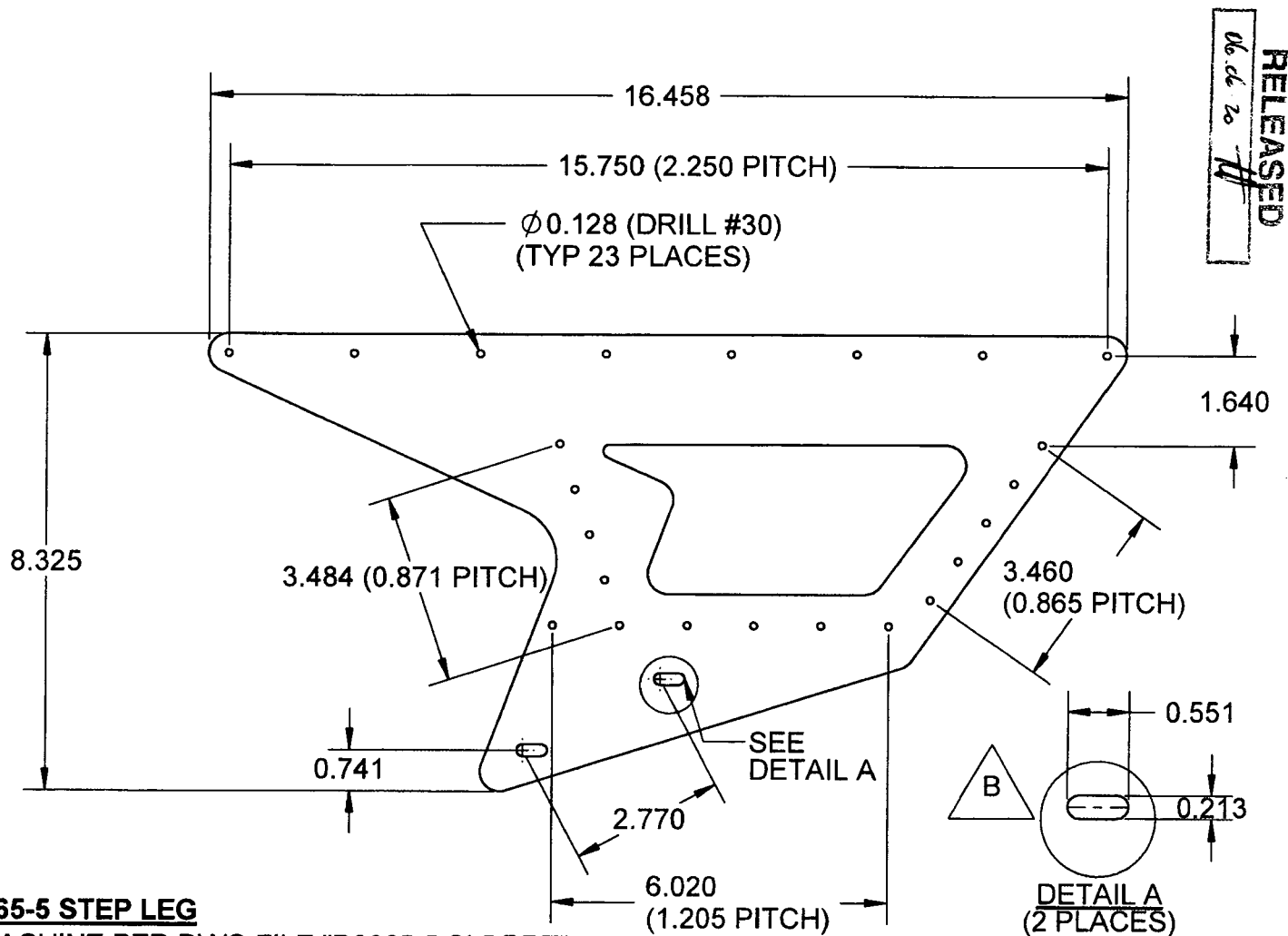
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DART

DESIGN	<i>CP</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	TITLE	D3065	REV. B
		STEP LEG ASSEMBLY		SHEET 4 OF 5
				SCALE 1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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